

Date: Monday, 5/15/2006 11:10:36 AM
 User: Kim Johnston

Process Sheet

SPLIT *06/06/13*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 27102 -1
 Estimate Number : 11036
 P.O. Number : *N/A* Part Number : D2804041
 This Issue : 5/15/2006 S.O. No. : *N/A* Drawing Number : D2804 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : 5/15/2006 Type : R & D SM/MED FAB Drawing Revision : B
 Previous Run : 25919 Material : *N/A*
 Written By : *SEA* Due Date : 6/5/2006 Qty: 20 Um: Each
 Checked & Approved By : *06.05.15*
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28041 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 STA 155 Bracket

Pick:

Qty Part Number Description Batch
 1 D2804-1 Bracket *B 27112*

2.0 D28051 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Stop

Pick:

Qty Part Number Description Batch
 1 D2805-1 Stop *B 27304*
B 25931

D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Bushing

Pick:

Qty Part Number Description Batch
 1 D2809 Bushing *B 25959*

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Press D2805-1 into arm as per Dwg D2804

m.f. 06/06/08

20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/06/07

20

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL

06/06/12

(20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAP 06:06:13

(2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

FF 06.06.13

2

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M17944

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3 Nut

M100218

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

M19633

A/R

LPS-3

Corrosion Spray

M17045

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SAP

06.06.13

(2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAP 06.06.13

(2)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAP

06.06.14

(2)

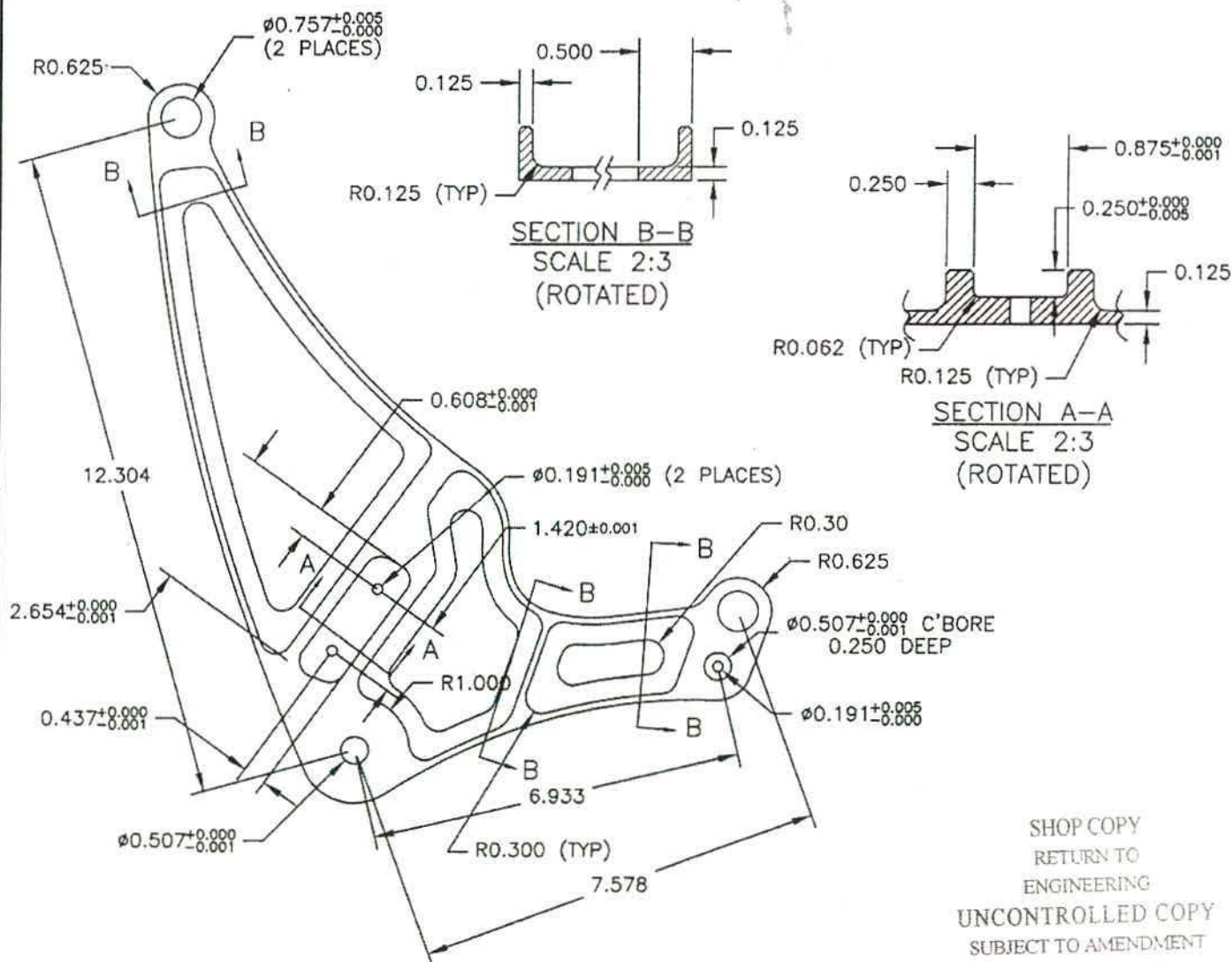
Job Completion



u 06.06.14

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED05.03.11 *[Signature]*

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WORK ORDER
NO. 27102

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

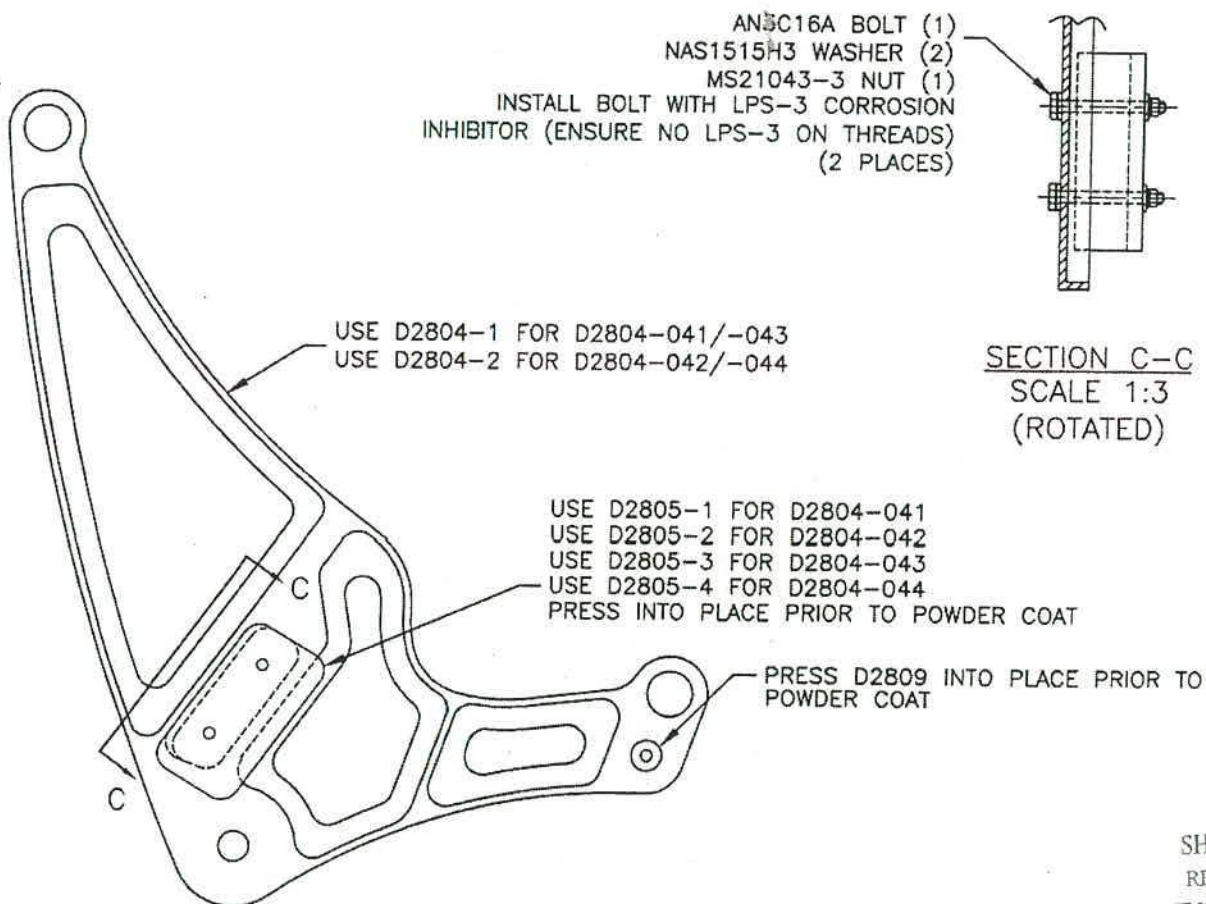
- 1) MACHINE PER DRAWING FILE "D2804.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE $R0.030 - 0.063$ ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



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RELEASED
WORK ORDER
05-03-11  NO. 27102

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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